

DUPLICATE - SHIP 14/11/24

ID 82649

82649

Page 1

9:52 AM

D4417-041

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Item Name: Step Assembly

Start Date: 4/04/12 Start Qty: 2.00 *2*

Required Date: 4/30/12 Req'd Qty: 2.00 *2*

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

Draw Nbr

Revision Nbr

D4417

B

100

0.00

100

Large Fab

0.00

Large Fab

Memo

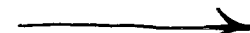
1-Cut D2622 to 106"AS PER DWG

2-DRILL HOLES USING DT9765

3-CUT ENDS AT 45 DEG AS PER DWG

3-Weld one cap D2734 AS PER DWG

4-Grind



110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Quality Control

Memo

0.00

Situstol



Ac 12.04.30

12.04.30

Ac 12.05.01



PTO ->

PTO ->

Dart Aerospace Ltd

W/O: 82649 WORK ORDER CHANGES								
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
12/05/01	#170	perm. change to QCIW inspection					12/05/01	
12/05/04	171	chemical conversion		12.05.14	2			

Part No: D4417-041 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82649

April-30-12 7:39:52 AM

82649

Page 2

Item ID: D4417-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Assembly

Start Date: 4/04/12 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 4/30/12 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

81265101

72

② 26 12-5-1

2 0

ll
12-05-12

Work Order ID 82649

82649

Page 3

April-30-12 7:39:52 AM

Item ID: D4417-041

Accept

N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Assembly

Start Date: 4/04/12 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 4/30/12 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

0.00

150

Large Fab

Large Fab

Memo

0.00

Large Fab

Weld last cap per dwg D4417 & grind flush

2-SWAGE TUBES AS PER DWG

3-grind flush

2 ϕ

12.05.04

160

QC10- Inspect visual per QSI004- ground welds

0.00

160

QC

Memo

0.00

Quality Control

8/7/04

170

QC5- Inspect part completeness to step on W/O

0.00

170

QC

Memo

0.00

Quality Control

8/7/04

(E)

12.05.04

171 → see w/o changes.

Work Order ID 82649

82649

Page 4

April-30-12 7:39:52 AM

Item ID: D4417-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Step Assembly

Start Date: 4/04/12 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 4/30/12 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start *NR1*

QC: Date:

SPC (Y/N): Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

180

Powdercoat

Powder Coating

Memo

1-Touch up alodine

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

7:40
3:20 OF
8:10

2X

✓

M-T
12/05/07

190

Wing Walk as per dwg QSI005 4.4 Batch 12/21

0.00

190

HandFinish

Hand Finishing

Memo

0.00

2 X

2P

12/05/07

200

QC3- Inspect Part Finish

0.00

200

QC

Quality Control

Memo

0.00

2

BL 12 58.

Work Order ID 82649***82649***

Page 5

April-30-12 7:39:52 AM

Item ID: D4417-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Step Assembly

Start Date: 4/04/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/30/12 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: **D4417-041****82650****2** **φ.** **BLD-5-8.*****210***

Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

12/5/14 **JD**
12-05-11

Picklist Print

April-30-12 7:39:52 AM

Page 1

Work Order ID: 82649
Parent Item: D4417-041
Parent Item Name: Step Assembly

Start Date: 4/04/12
Start Qty: 2.00

Required Date: 4/30/12
Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC
REV:B DD VERF:JLM . IPP REV:B 11.08.17 PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2622-120C Step Extrusion		Manufactured	No			100	Each	129.7300	1	2			

Location	Loc Qty	Loc Code
HALL	16.37	
46910	2	
64409	6	
66970	7.7	
68293	0.25	
72131	0.42	
WA	104	
81507	104	
WA013	9.36	
75781	2	
77612	7.36	

At 12.04.30

D2734 Step End Plate		Manufactured	No			100	Each	53.0000	1	2			
-------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA	53	
76985	25	
80682	28	

At 12.05.02

D2734 Step End Plate		Manufactured	No			150	Each	53.0000	1	2			
-------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA	53	
76985	25	
80682	28	

At 12.05.02

Picklist Print

April-30-12 7:39:52 AM

Page 2

Work Order ID: 82649

Parent Item: D4417-041

Parent Item Name: Step Assembly

Start Date: 4/04/12

Required Date: 4/30/12

Start Qty: 2.00

Required Qty: 2.00

D4425-1

Manufactured No

150

Each

6.0000

2

4

Step Spacer

12.05.02

Location

Loc Qty

Loc Code

WA003

6

73194

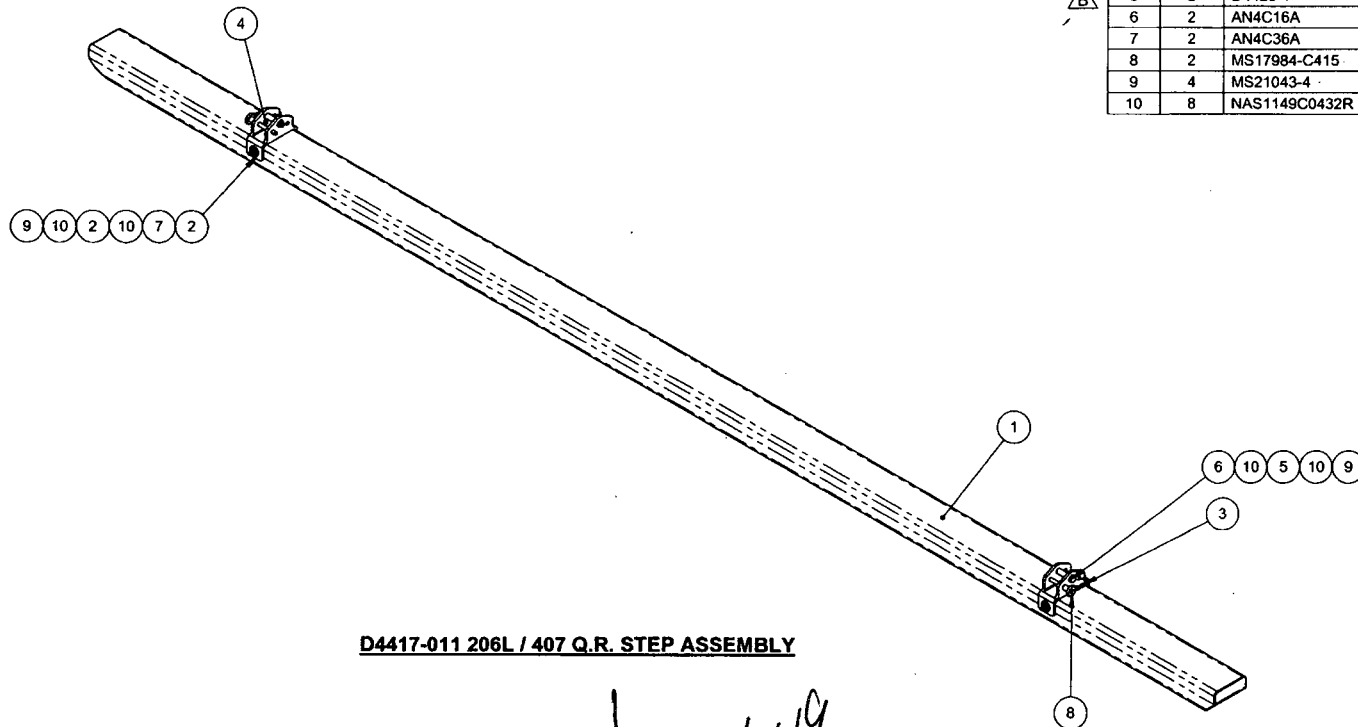
6

4

April-30-12 7:39:52 AM

Shop Packet Print

Page 2



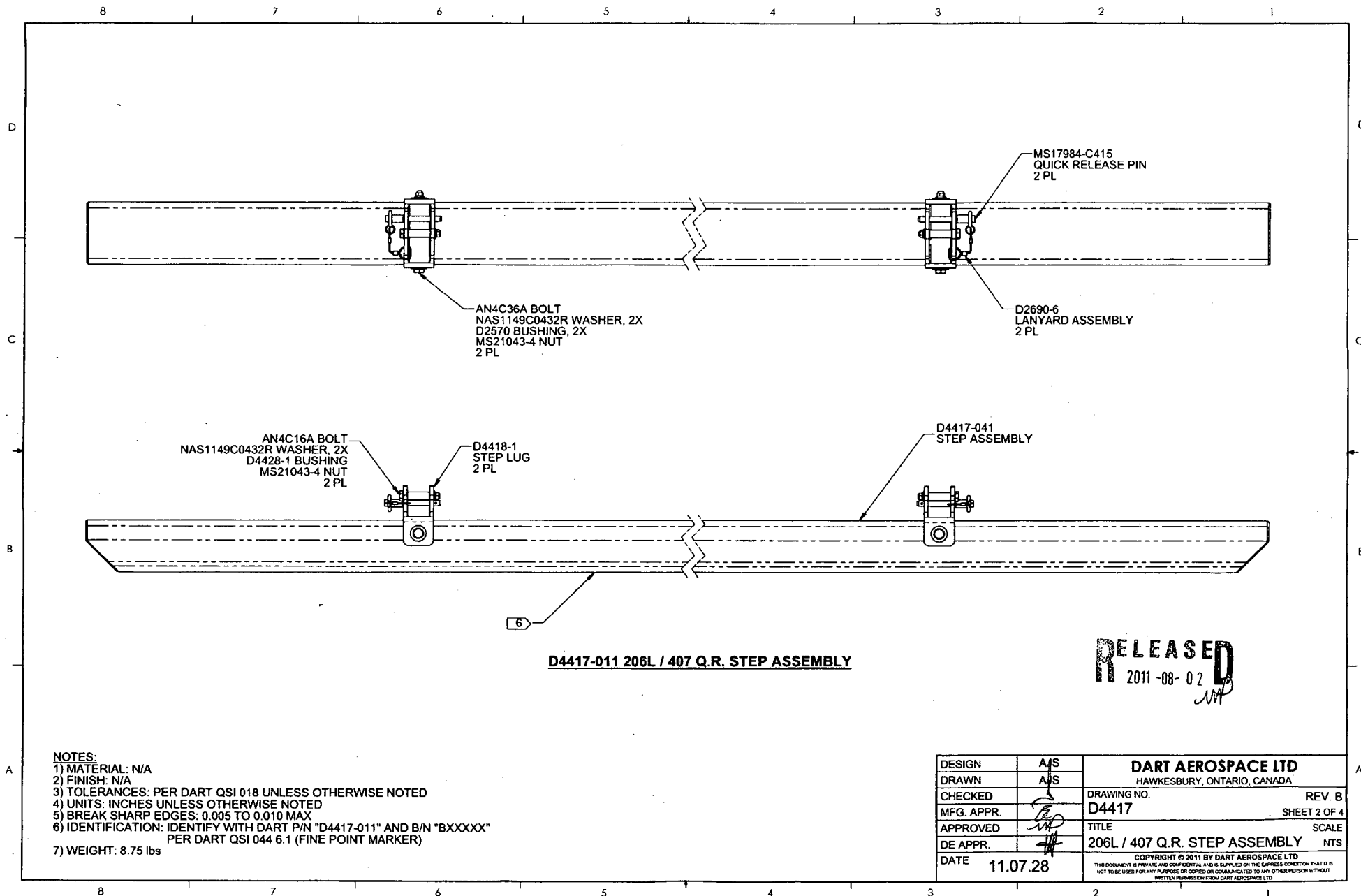
D4417-011 206L / 407 Q.R. STEP ASSEMBLY

W/082649

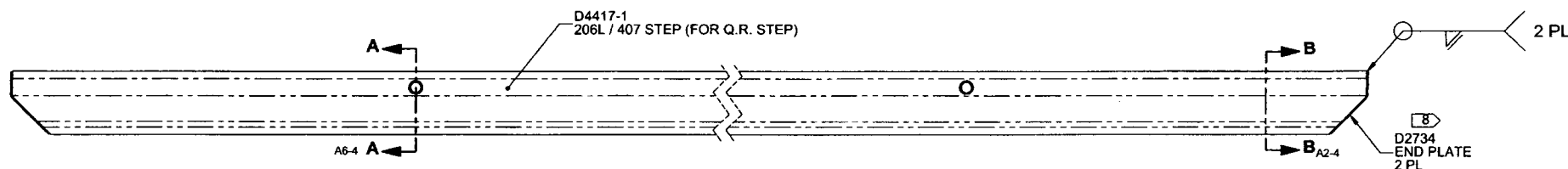
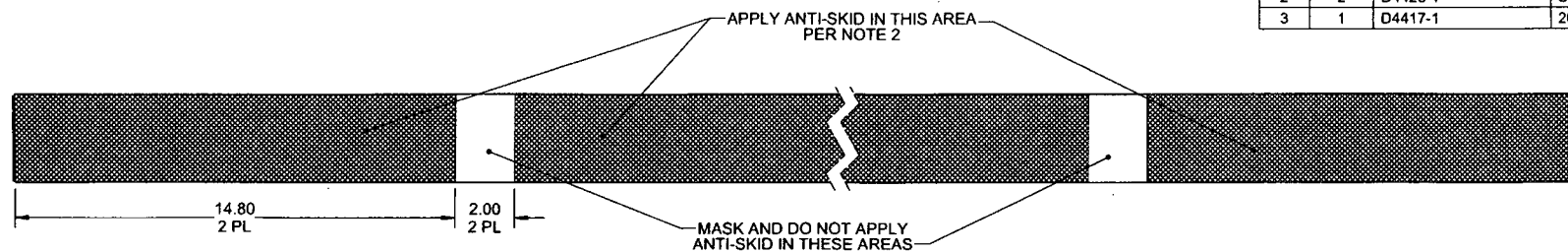
ITEM	QTY	P/N	DESCRIPTION
	X	D4417-011	206L / 407 Q.R. STEP ASSEMBLY
1	1	D4417-041	STEP ASSEMBLY
2	4	D2570	BUSHING
3	2	D2690-6	LANYARD ASSEMBLY
4	2	D4418-1	STEP LUG
5	2	D4428-1	BUSHING
6	2	AN4C16A	BOLT
7	2	AN4C36A	BOLT
8	2	MS17984-C415	QUICK RELEASE PIN (BLBS-020)
9	4	MS21043-4	NUT
10	8	NAS1149C0432R	WASHER

RELEASED
2011-08-02

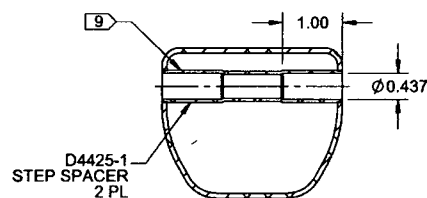
B	REPLACED NAS430D4-64 SPACER WITH ITEM 5. ITEM 3 WAS -5.	AJS	11.07.28
A	NEW ISSUE	AJS	11.07.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.07.28		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4417 TITLE 206L / 407 Q.R. STEP ASSEMBLY SCALE NTS <small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			



ITEM	QTY	P/N	DESCRIPTION
	X	D4417-041	STEP ASSEMBLY
1	2	D2734	END PLATE
2	2	D4425-1	STEP SPACER
3	1	D4417-1	206L / 407 STEP (FOR Q.R. STEP)

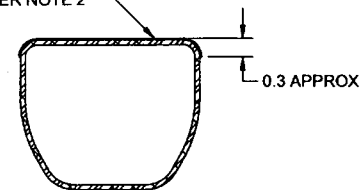


D4417-041 STEP ASSEMBLY



SECTION A-A C7-4
SCALE 2X

APPLY ANTI-SKID IN THIS AREA
PER NOTE 2



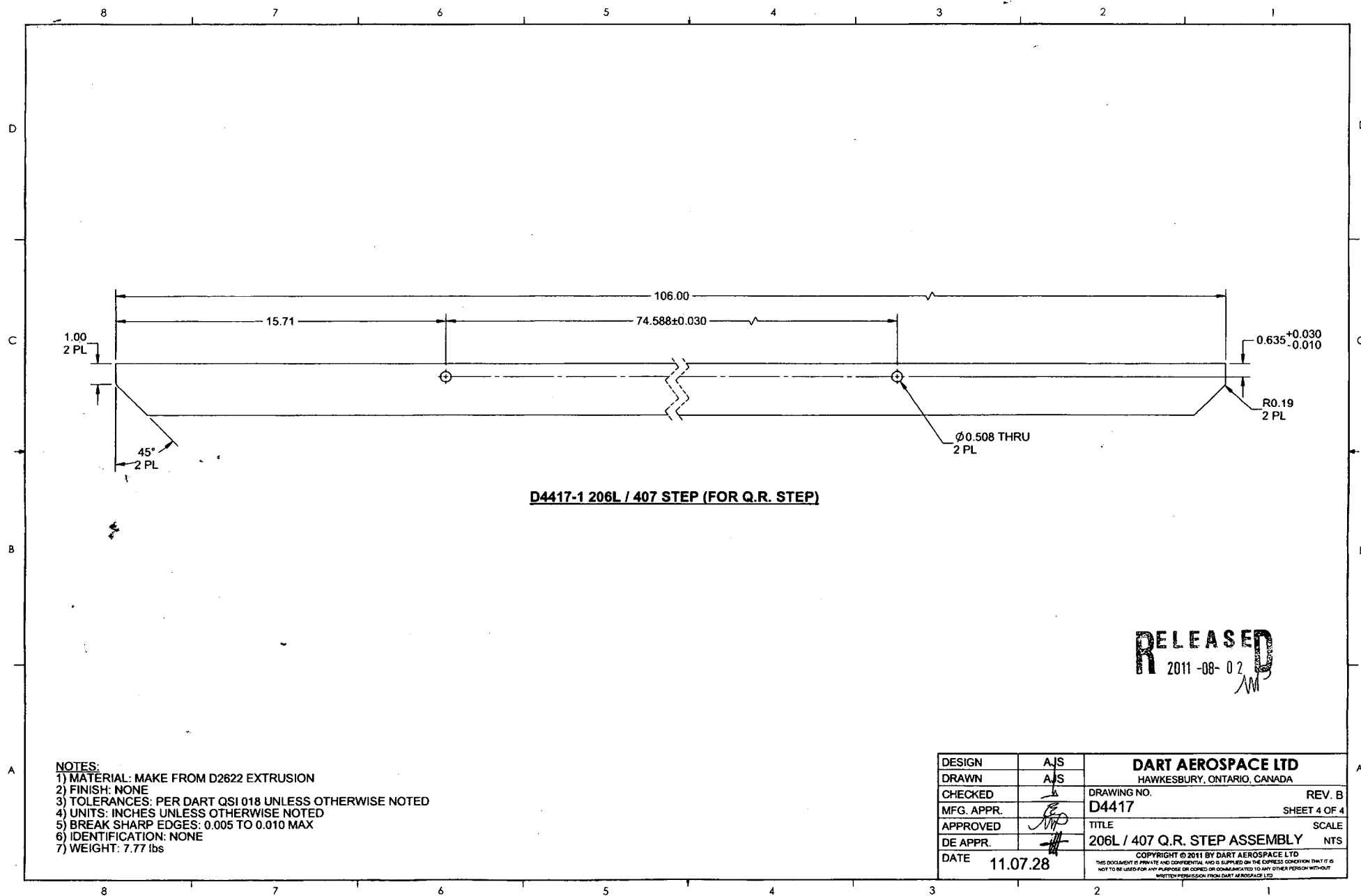
SECTION B-B C2-4
SCALE 2X

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.00 lbs
- 8) APPLY ALODINE AFTER WELDING ON THE D2734 END CAPS AND
PRIOR TO INSTALLATION OF D4425-1 STEP SPACERS.
- 9) SWAGE TO Ø0.437 X 1.00 DEEP PER QSI 002



DESIGN	AJS	DART AEROSPACE LTD	
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CHECKED	AJS	DRAWING NO.	REV. B
MFG. APPR.	AJS	D4417	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	206L / 407 Q.R. STEP ASSEMBLY	NTS
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RELEASED
2011-08-02
MP



RELEASED
2011-08-02

- NOTES:**
- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 7.77 lbs

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D4417	REV. B
MFG. APPR.		SHEET 4 OF 4	
APPROVED		TITLE	SCALE
DE APPR.		206L / 407 Q.R. STEP ASSEMBLY	
DATE	11.07.28	NTS	
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